



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3910-3**Job Sheet 198569**

30 PART

Part No: D3910-3**Job Qty:** 24 pcs**Part Name:** Crosstube Lug**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 7/31/19**Job Tracking No:****Due Date:** 9/9/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV E SHEETS 1,3 IPP REV:A NEW ISSUE 09-11-25 JLM VERIFIED BY:DD IPP REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD IPP REV:C 18.02.02 REMOVE FINISH DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Purchasing	24 pcs	9/9/19	9/9/19	0.00	0.00	Purchasing - 1	5	DP AUG 09 2019
							Purchasing - 2	5	
							Purchasing - 3	5	
120	Packaging 2-1 - Receive - B4B	24 pcs	9/9/19	9/9/19	0.00	0.00	Packaging 2 - 1 - B4B		DP AUG 09 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		

Plex 7/31/19 7:39 AM Dart.lajeunesse.marie



Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S204347**Part:** D3910-3**Job No:** 198569**Serial No/Batch:** S204347**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 08/09/19

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130 QC 6	24 pcs	9/9/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	AUG 23 2019
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	24 pcs	9/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	PK ST 523
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	24 pcs	9/9/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	

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AUG 23 2019

PK ST 523

AUG 30 2019

Part Op 110 - (Purchasing) ISSUE PO TO METEC, NOTE ALODINE AND PAINT AS PER QSI 005
Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach
130 - (QC6- All purchased or subcontracted products)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

POH6044214 x 30 fls aug 07 2019

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2423	Lug Extrusion	3 ft (.125 ea)	110-Purchasing	5141 186	
D3910-3P	Crosstube Lug	24 pcs (1 ea)	110-Purchasing	5204 344	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Purchasing	D2423	3	447	0	
	D3910-3P	24	0	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crosstube Lug	4.450Inches ± 0.030	4.480 4.420		
2	Crosstube Lug	1.380Inches ± 0.030	1.410 1.350		
3	Crosstube Lug	0.080Inches ± 0.020	0.100 0.060	Radius	
4	Crosstube Lug	0.270Inches ± 0.030	0.300 0.240	reference	
5	Crosstube Lug	0.310Inches ± 0.030	0.340 0.280		
6	Crosstube Lug	0.735Inches ± 0.010	0.745 0.725	reference	
7	Crosstube Lug	1.200Inches ± 0.030	1.230 1.170	Radius	
8	Crosstube Lug	3.700Inches ± 0.010	3.710 3.690		
9	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
10	Crosstube Lug	0.625Inches ± 0.010	0.635 0.615		
11	Crosstube Lug	0.375Inches ± 0.010	0.385 0.365		
12	Crosstube Lug	0.340Inches ± 0.030	0.370 0.310	Radius	
13	Crosstube Lug	0.257Inches + 0.006 - 0.001	0.263 0.256	Diameter	
14	Crosstube Lug	0.100Inches ± 0.010	0.110 0.090		
15	Crosstube Lug	45.000Degrees ± 0.500	45.500 44.500	angle	
16	Crosstube Lug	1.410Inches ± 0.030	1.440 1.380	Reference	

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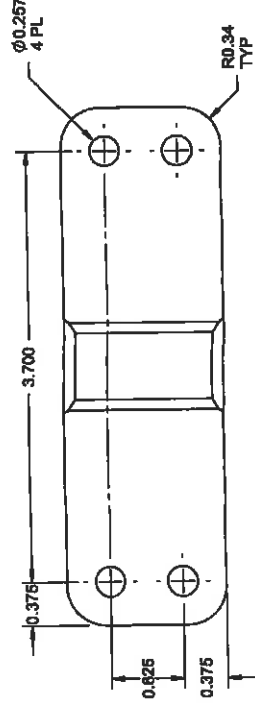
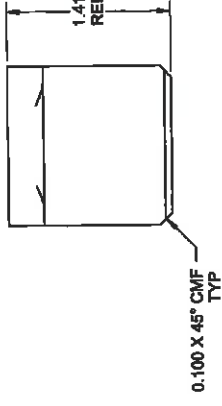
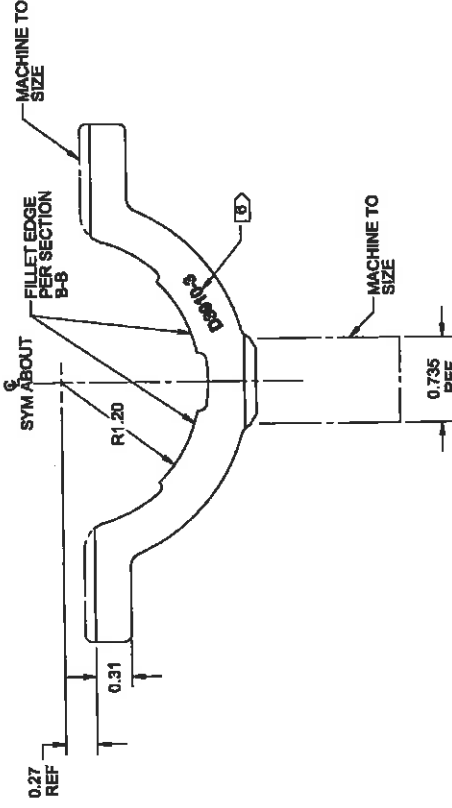
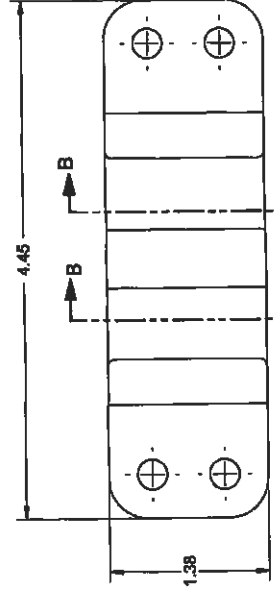
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 198569 MS
190731



ROUND EDGE
R0.08 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

RELEASED
20th JUN 05

DESIGN	AJS	DART AEROSPACE LTD	REV. E
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3910	SHEET 3 OF 5
MFG. APPR.		TITLE X-TUBE LUG (350)	SCALE
APPROVED			NTS
DE APPR.			
DATE	14.05.16		

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



Route update only ☐

NCR No. _____

Job: _____ Part No. _____		DISPOSITION ☐ Rework ☐ Scrap ☐ Use-as-is		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Pressure/Forced ☐ Contamination ☐ Power Loss/Surge ☐ Bending ☐ Misaligned/off center ☐ Folio/Program ☐ Crushing ☐ BOM/Route ☐ Grain Direction ☐ Cracks ☐ Broken/Damage/Defect ☐ Weld ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Marks/Chatter ☐ Drill Holes ☐ Out of Sequence ☐ Mislabeled ☐ Fit/Function ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details:							



DART
AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044214



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044214
PO Date: 8/7/19
Due Date: 8/21/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:
Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198619	D4091-1P			Lug : Various STC's As Per Dwg D4091 Rev. A Alodine and Paint as Per QSI 005	Firmed	-	8/21/19	30 pcs	0 pcs	30 pcs	\$17.40/pcs	\$522.00
						X30			AUG 09 2019				DP
2	198570	D3910-5P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/21/19	30 pcs	0 pcs	30 pcs	\$17.40/pcs	\$522.00
						X30			AUG 09 2019				DP
3	198569	D3910-3P			Crosstube Lug : Various STC's As Per Dwg D3910 Rev. E Alodine and Paint as Per QSI 005	Firmed	-	8/21/19	30 pcs	0 pcs	30 pcs	\$17.40/pcs	\$522.00
						X30			AUG 09 2019				DP
Grand Total:													\$1,566.00

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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB044214

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

- Procurement Quality Clauses
- A005 RIGHT OF ENTRY
 - A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
 - A012 CHEMICAL AND PHYSICAL TEST REPORTS
 - A016 PERSONNEL QUALIFICATION
 - A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
 - A026 CERTIFICATION OF MATERIAL CONFORMANCE
 - A041 QUALITY MANAGEMENT SYSTEM
 - A042 DART NOTIFICATION BY SUPPLIER
 - A043 RETENTION OF QUALITY DOCUMENT
 - A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
 - A049 SUPPLIER AWARENESS

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Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 25676	Customer Code: DART
Shipment Date: 08-Aug-2019	Phone: (613) 632-9577
Ship Via: Pick up at METEC	PO Number: POHB044214
Order Number: 4078	Terms: Net 60 Days
Order Date: 08/08/2019	

Quantity					Unit	Description	Revision	Job Number
Item	Open	Shipped	B/O	Canceled				
1	30	30	0	0	EA	DART-D4091-1P Lug alodined and painted as per QSI 005	A	4078-01
2	30	30	0	0	EA	DART-D3910-5P Crosstube Lug, alodined and painted as per QSI 005	E	4078-02
3	30	30	0	0	EA	DART-D3910-3P Crosstube Lug alodined and painted as per QSI005	E	4078-03

RECEIVED

AUG 08 2019

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

DART AEROSPACE LTD.

Received In Good Order By
 Dart Aerospace Ltd.



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
30	D4091-1	Lug	A	S101247	016012-1	HB044214
30	D3910-5	Crosstube Lug	E	S141186	019481-1	HB044214
30	D3910-3	Crosstube Lug	E	S141186	019114-1	HB044214

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MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


Heather Nixon

Vankleek Hill, August 8, 2019